LET	ALTERATION	DATE	BY	LET	ALTERATION	DATE	BY
				A	TRACED - NO WT. CHG.	[illegible]	[illegible]

28W025 L.H.
28W023-1 R.H.

PLAN VIEW
SCALE: 1½" = 1'-0"

Q9901-12 ON TOP SURFACE
Q9901-16 ON BOTTOM SURFACE
-14 FABRIC PATCH
-13
-19 (REF.)
-16 REINF. TAPE
-3 FABRIC COVER
-25 SEE DETAIL
28W171-7 DOPE ON OVER THIS HOLE
CUT ½ DIA. HOLE THRU TAPE & FABRIC
Q506A-2-4 (REF.)
-19 SEAM TYPE LSQ-2
SEAM TYPE LSQ-2
-18 TAPE-COTTON
-5 TOP & BOTTOM
END REINF. TAPE -16 HERE UPPER & LOWER SURFACES

7 ADD'L DRAIN HOLES
NOTE: TO BE LOCATE 12" FROM TR. EDGE FOR PBY-5A, 28-5AMC & 28-5AMN
¼ DIA. HOLES 7 PLACES TAN TO RIB(LOWER SURFACE)

¼ DIA. HOLES 7 PLACES TAN. TO GUSSET & TR. EDGE SECTION. (LOWER SURFACE)
NAF 213095-3 GROMMET (7) LOCATE ON LOWER SURFACE AT INBOARD END OF EACH BAY BETWEEN RIBS.
28W011-29 PATCH - DOPE OVER ALL HOODED GROMMETS.

DETAIL -25 TAPE PATCH
1½ DIA.

CHORD LINE
AFTER ASSEMBLY ON WING, THE MAX. DEVIATION FROM CHORD LINE SHALL BE ± 3/16

FILE FLUSH
(REF.) 1Q548-3
-6 SEWING STRIP
-20 TAPE-COTTON
REAR FLANGE OF SPAR
SEW INSIDE EDGE OF PINKED EDGE TAPE TO LOOP IN FABRIC DOPE OUTER EDGE OVER SCREWS
Q5033A-4-6 APPROX. 2" ON ℄S BETWEEN RIBS

TYPICAL SECTION A-A
UPPER & LOWER SURFACE
FULL SIZE

WHERE NECESSARY DRILL HOLES IN .020 SKIN FOR SEWING.- HAND SEW

SECTION C-C
FULL SIZE

SECTION D-D
FULL SIZE

-5 (REF.)
-21 (REF.)
DRILL #44 (.086)
Q5033A-4-4

SECTION G-G
FULL SIZE

BINDING HEAD PARKER-KALON SELF-TAPPING SCREW SPACE APPROX 5" AND LOCATE TO CLEAR ALL RIVETS. SCREWS TO BE CAD. PLATED STEEL; MINIMUM PLATING .0005" THICK

-5 (REF.)
-16 (REF.)

TYPICAL SECTION SHOWING RIB LACING KNOT TO BE AS SHOWN IN FIG. 9 SPEC. SR63 KNOT TO BE LOCATED 6 RIB FOR PBY-4 AND FUTURE. SPACE LACING 2 IN.

1Q548-3
Q5103-5(6)
LOCATE TO CLEAR RIVETS
AN23-10A
AC365-1032
INBOARD
OUTBOARD
-7 FILLER
-9 FILLER
-10 FILLER

SECTION F-F
SCALE - 6" = 1'-0"

1Q548-3
-8 FILLER
1Q548-6
AN23-12A
AC365-1032
-11 FILLER
OUTBOARD
INBOARD

SECTION E-E - TYPICAL SCREW SPACING AT RIBS
SCALE 6" = 1'-0"

-21 WASHER
SCALE 24" = 1'-0"

STOP SEWING BODY FABRIC HERE
¼ DIA. HOLE IN TRAIL EDGE PIECE HERE
¼ DIA. HOLE IN -16 TAPE
TUCK FABRIC UNDER TO GET CLEAN EDGE
⅜ DIA. HOLE IN BODY FABRIC

VIEW H-H
SCALE 12" = 1'-0"

NOTE: VIEW HH SHOWS TYPICAL FABRIC ATTACHMENT AROUND DRAIN HOLES IN TR. EDGE
NOTE: LIMITS ON ALL CONTOUR DIM'S ±1/32 UNLESS OTHERWISE SPECIFIED.

DOPING PROCESS FOR PBY-2, PBY-3 & PBY-4

ALL FABRIC COVERED SURFACES SHALL BE DOPED AS PER SPEC. SR70 EXCEPT THAT THE MATERIALS & COATS SHALL BE AS FOLLOWS:
ALL SURFACES TO BE GIVEN—
1: 4, OR MORE COATS IF NECESSARY, TO GET PROPER TAUTNESS, OF CLEAR NITRATE DOPE SPEC. D-15 WITH THINNER SPEC. T-25
2: 2 COATS OF PIGMENTED DOPE WITH THINNER, SPEC. T-25; FIRST 2 COATS BRUSHED ON, LAST 4 MAY BE SPRAYED. LAST 2 COATS ON UPPER SURFACE SHALL BE ORANGE-YELLOW PIGM. DOPE SPEC. D-16. LAST 2 COATS ON ALL OTHER SURFACES SHALL BE AL. PIGM. DOPE; CONSISTING OF 2½# OF #325 MESH AL. GREY PASTE TO 5 GAL. CLEAR NITRATE DOPE - SPEC. D-15 REF. 28E 2048
DOPING FOR PBY-1 -- SPEC. SR70 - 5 COATS CLEAR NITRATE DOPE - SPEC. 52D2 - BRUSH 3. - SPRAY 2. 2 COATS PIGMENTED DOPE SPEC. 52D4a (SPRAYED). ALUMINUM COLOR - BOTTOM SURFACE. ORANGE-YELLOW COLOR - TOP SURFACE. COVER & DOPE ON FALSE SPAR.

FABRICS TABLE (QUANTITIES ARE PER TR. EDGE)

COVERING PER SPEC. SR63A FOR PBY-5
COVERING PER SPEC. SR63
DOPING PER SPEC. SR70 & AS NOTED
FABRIC COVER -3 COTTON SPEC. 49C13 GRADE A 8 YDS x 90" WIDE
PINKED EDGE SURFACE TAPE -5 SPEC. 27T14 2½" WIDE 32 YDS.
PINKED EDGE -18 6" WD. x 3½ YDS. GRADE A TAPE COTTON SPEC. AN-CCC-C-399
PINKED EDGE SURFACE TAPE -19 SPEC. 27T14 5" WIDE x 10 YDS.
FABRIC ZIPPER PATCHES -13, -14 SPEC. 49C13 GRADE A COTTON 60" x 1 YD.
LACING CORD SPEC. V-T-291, 11 PLY, TYPE B R.H. TWIST, PRE-COLD WAXED 40 YDS.
TWILLED REINFORCING TAPE -16 COTTON - SPEC. 27T13 35 YDS. (WIDTH ½")
DOPE - CLEAR 11½ GAL. ORANGE-YELLOW 1½ GAL. ALUM. PIGM. 1½ GAL.
THREAD FOR MACHINE SEWED SEAMS TO BE AS FOLLOWS - FOR BOBBIN, COTTON TH'D SPEC. V-T-276 NO. 16 4 CORD TYPE IA L.H. TWIST - FOR NEEDLE, COTTON TH'D SPEC. V-T-276 NO. 16 4 CORD TYPE IB L.H. TWIST.
THREAD FOR HAND SEWING TO BE LINEN SPEC. V-T-291, NO. 30, 3 CORD, R.H. TWIST
PINKED EDGE TAPE -20 GRADE A COTTON SPEC. 49C13 3¼" WIDE x 6 YDS.
SHOP DRIVEN RIVET HEADS AND ALL SHARP EDGES CONTACTING FABRIC ARE TO BE COVERED WITH ADHESIVE TAPE.
COVER IS SEAMLESS BLANKET TYPE.
APPLY BEESWAX, SPEC. 52B4 PER SPEC. SR63a TO LACING CORD
MACHINE SEWED SEAMS TO BE IN ACCORDANCE WITH FED. SPEC. DDD-S-751
COVERING TO BE IN ACCORDANCE WITH LATEST EFFECTIVE REVISION OF SPEC. SR63

ALL FIBRE FILLERS AND SEWING STRIPS ARE GRADE 5 BLACK "SPALDITE" SPALDING FIBRE CO. TONAWANDA, N.Y.

PART No.	STOCK	MATERIAL	SPEC.	-0 LH REQ.	-0 RH REQ.	-2 LH REQ.	-2 RH REQ.	-3 LH REQ.	-3 RH REQ.	-4 LH REQ.	-4 RH REQ.	-5 LH REQ.	-5 RH REQ.
AC365-1032				2	2	2	2						
NAF-213095-3				7	7	14	14						
AN23-12A				1	1	1	1						
AN23-10A				1	1	1	1						
1Q548-6				1	1	1	1						
1Q548-3				144	144	144	144						
Q9901-16				2	2	2	2						
Q9901-12				4	4	4	4						
Q5103-5				6	6	6	6						
Q5033A-4-6				160	160	160	160						
Q5033A-4-4				87	87	87	87						
28W171-7				1	1	1	1						
28W023-1					1		1						
28W023				1		1							
28W011-29				7	7	14	14						
-25	2⅞ x 2⅞	[illegible]	27T14	1	1	1	1						
-21	.016 x ½ x ½	24ST ALC	47A8-T	87	87	87	87						
-20	3¼ x 106½	[illegible]	49C13	NOTED									
-19	10 YDS. 5" WD.	[illegible]	27T14	NOTED									
-18	3½ YDS. 6" WD.	[illegible]	AN-CCC-C-399	NOTED									
-16	35 YDS ½" WD.	REINF. TAPE	27T13	NOTED									
-14	60" x 1 YD.	FABRIC PATCH	49C13	2	2	2	2						
-13	60" x 1 YD.	FABRIC PATCH	49C13	1	1	1	1						
-11	[illegible]	BLACK FIBRE	"SPALDITE"	1	1	1	1						
-10	[illegible]			1	1	1	1						
-9	[illegible]			1	1	1	1						
-8	[illegible]			1	1	1	1						
-7	[illegible]			1	1	1	1						
-6	[illegible] x 106½	BLACK FIBRE	"SPALDITE"	2	2	2	2						
		PINKED EDGE											
-5	32 YDS. 2½" WD.	[illegible] TAPE	27T14	NOTED									
-3	8 YDS. 90" WD.	COVER FABRIC	49C13	1	1	1	1						

PARTS LIST PER ASSY.

DASH No.	MODEL	NEXT ASSY.	REQ.
[illegible]	PBY-5A	28W006	[illegible]
[illegible]	PBY-5		[illegible]
[illegible]	28-5AMN		[illegible]
[illegible]	PBY-5B		[illegible]
[illegible]	28-5AMC		[illegible]
[illegible]	28-5MN		[illegible]
[illegible]	28-5ME		[illegible]
[illegible]	28-5MC		[illegible]
[illegible]	28-5MA		[illegible]
[illegible]	PBY-3 & 4		[illegible]
[illegible]	PBY-1 & 2	28W004	[illegible]

REQUIREMENTS PER AIRPLANE

REPLACES 28W024 1-22-35
REPLACED BY
70
SCALE NOTED
1/32

A C
NAVY NONE | NOTED
HEAT TREAT | FINISH
T.P.F. 1-22-35

H 493

COVERING ASSY WING
OUTER PANEL-TRAILING EDGE

OPP. HAND 28W024-RH
J 28W024

CONSOLIDATED AIRCRAFT CORP. SAN DIEGO, CALIF.

R 28W024